

Work Order ID 66379

February 14, 2011 8:32:56 AM

RUSH!



Item ID: D3216-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 2/14/11

Start Qty: 5.00



Cust Item ID:

Required Date: 2/15/11

Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date:

11/02/14

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3216

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3216
Deburr if necessary

☐ Dwg Rev:

A

☐ Prog Rev:

A

☐ 2-

1311-2-14

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1311-2-14

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/11/2/14

(710)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66379

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble until parts have a polished finish.

11-2-15

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/15

410

150

0.00



Identify as per dwg & Stock Location: 41

Packaging

Memo

0.00

Packaging

11/2/15

SP 1101

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/02/15

MF
11-02-15

Picklist Print

Page 1

February 14, 2011 8:32:56 AM

Work Order ID: 66379



Parent Item: D3216-1

Parent Item Name: Fitting


Start Date: 2/14/11

Required Date: 2/15/11

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: A 03.10.28 New Issue KJ/RF
IPP Rev: B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	52.2800	0.0288	0.151579			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT		52.28							
				116623		52.28							



B11-2-14

116623

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

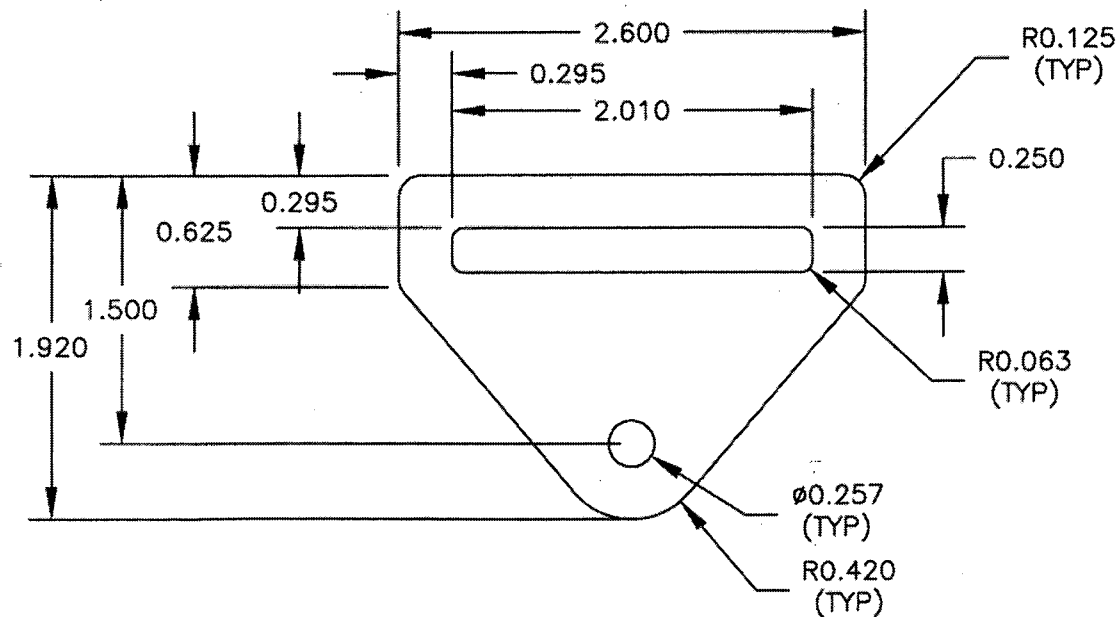
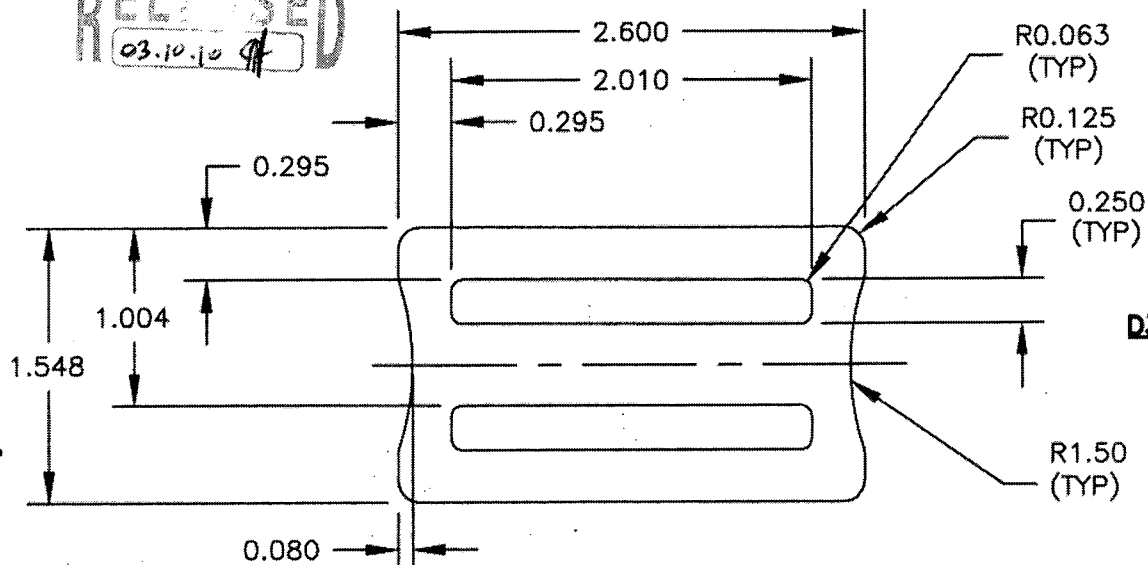
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3216	REV. A SHEET 1 OF 1
DATE 03.09.26		TITLE FITTING	SCALE 1:1
A	03.09.26	NEW ISSUE	

RELEASED
03.10.10 *[Signature]*



D3216-1/-3 FITTING

- 1) MATERIAL: AISI 304/316 PLATE, 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: MOLECRO POLISH
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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WORK ORDER

NO. *62329*
C211/02/14

DART AEROSPACE LTD		Work Order:	66379
Description: Fitting		Part Number:	D3216-1
Inspection Dwg: D3216	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.600	+/-0.010	2.601	✓		✓ BOZ	
2.010	+/-0.010	2.015	✓		✓	
0.295	+/-0.010	0.295	✓		✓	
1.548	+/-0.010	1.554	✓		✓	
1.004	+/-0.010	1.009	✓		✓	
0.295	+/-0.010	0.299	✓		✓	
0.250	+/-0.010	0.250	✓		✓	
0.125	+/-0.010	0.119	✓		✓	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-2-14	Date: 11/02/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	[Signature]